

Work Order ID 57927

April 20, 2010 10:05:42 AM



Page 1

Item ID: D3404-1

Accept



Setup Start



Revision ID:

Item Name: GHW Lug

Stop



Start Date: 20/04/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-4-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3404

Rev C

100



BAND SAW

0.00

Bandsaw

Memo

0.00

anf 10/04/21

20 0

Jeaspa Bandsaw

Cut blank: 2.750" long

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

anf S.F 10/04/28

20 0

HAAS CNC vertical machine #1

1-Machine as per Folio FA555 and Dwg D3404 □ Dwg Rev: C Folio Rev:

AA □ 2-Debur

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

anf 10/04/29

20 0

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/
Work Center ID

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Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

mv=
10/04/29

20 *0*

140

Identify as per dwg & Stock Location *Enrich*
WP

0.00



Packaging

Memo

0.00

Packaging

10-5-4 *sf* *10-5-4*

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/04 *mf* *10-5-4*

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Picklist Print

April 20, 2010 10:05:47 AM

Page 1

Work Order ID: 57927



Parent Item: D3404-1



Parent Item Name: GHW Lug

Start Date: 20/04/2010

Required Date: 29/04/2010

Comments: IPP Rev:A ☐ 05.09.01 ☐ New issue ☐ KJ/JLM ☐

Start Qty: 20.00

Required Qty: 20.00

IPP rev B 09.01.28 new geometry rev.C EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.750X2.500		Purchased	No			100	f	28.1000	4.8232			



304 BAR .750 X 2.50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT53

28.1

→ 112663

14

112697

14.1

4.8232 mhd 10/04/21

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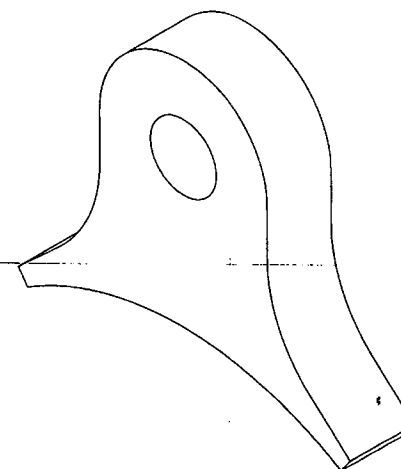
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 57927

PS 10-4-20



D3404-1 GHW LUG

RELEASED
08/12/02

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.	AJS	08.12.02
B	UPDATE M-SPEC	PH	05.06.14
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3404	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GHW LUG	NTS
DATE	08.12.02	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

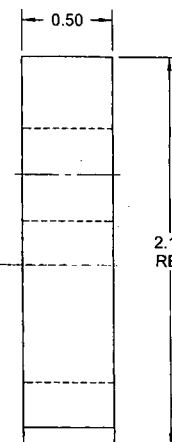
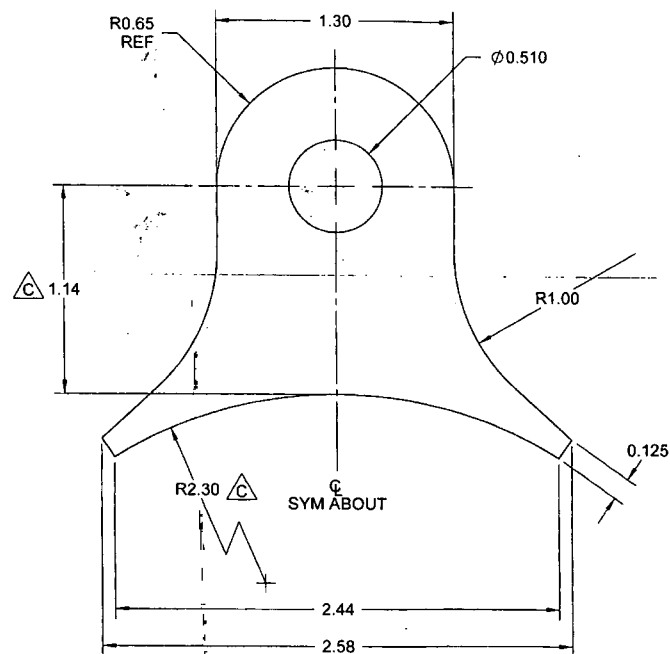
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W/0 57927

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CHECKED		DRAWING NO.	REV. C
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